

Date: Tuesday, 4/25/2006 7:35:43 AM
 User: Kim Johnston

Process Sheet



Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 26798		Part Number	: D3140303	
Estimate Number	: 11474		Drawing Number	: D3140 REV D1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 4/25/2006	S.O. No. : N/A	Drawing Revision	: D1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 5/1/2006	
Previous Run	: 25735		Qty:	1 Um: Each	
Written By	: See A Comment Below				
Checked & Approved By	: JG 04.25				
Comment	: Est. A02.11.06 New issue KJ/RF Est. Rev B New dwg rev. ecn781 06.04.18 EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet
Comment: Qty.: 2.9166 sf(s)/Unit Total : 2.9166 sf(s) 6061-T6 .063 Sheet Material: 6061-T6 (QQ-A-250/11) 0.063" thick(M6061T6S.063) Batch: M/9326 Identify as D3140-303		
2.0	SHEAR	SHEAR
Comment: SHEAR Water Jet Cut blanks: 48.700" x 7.250" ORG rev! <u>D1</u> Dwg rev! <u>D1</u> <u>04.04.25 (3)</u>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3140-303 as per Folio FA316 and Dwg D3140 Deburr		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>04.04.25 (3)</u>		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>06.04.25 (3)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: DOUBLER	
Job Number: 26798	Part Number: D3140303	
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
8.0	PACKAGING 1	PACKAGING RESOURCE #1 
9.0	DC	DOCUMENT CONTROL 

Job Completion



u 06.04.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
<p><i>REVIEWED</i> <i>05.12.01</i> <i>TH</i></p>		A 02.04.18	NEW ISSUE
		B 03.01.23	REMOVE -65/-81/-83; ADD -301/-303
		C 04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106*
		D 05.11.23	ADD -103/-104/-105/-106; REMOVE -67
		D1 <i>TH</i> 06.03.31	1.75 WAS 1.88; 4.75 WAS 4.13

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
			1	X		D3140-09	DOUBLER ASSEMBLY
				1	X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
			1	1		D3140-71	PAD
				1		D3140-73	PAD
					1	D3140-75	PAD
						D3140-77	PAD
						D3140-79	PAD
					1	1	D3140-85 ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
				1		D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
1						D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
			2	2		D3140-101	DOUBLER
			1			D3140-103	DOUBLER
				1		D3140-104	DOUBLER
					1	D3140-105	DOUBLER
						D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
1			1			D3140-303	DOUBLER
					5	5	MS20426AD3-4 RIVET
							WORK ORDER NO. <i>56798</i>



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. D SHEET 2 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
05.12.04
[Signature]



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

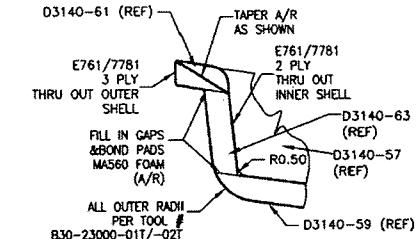
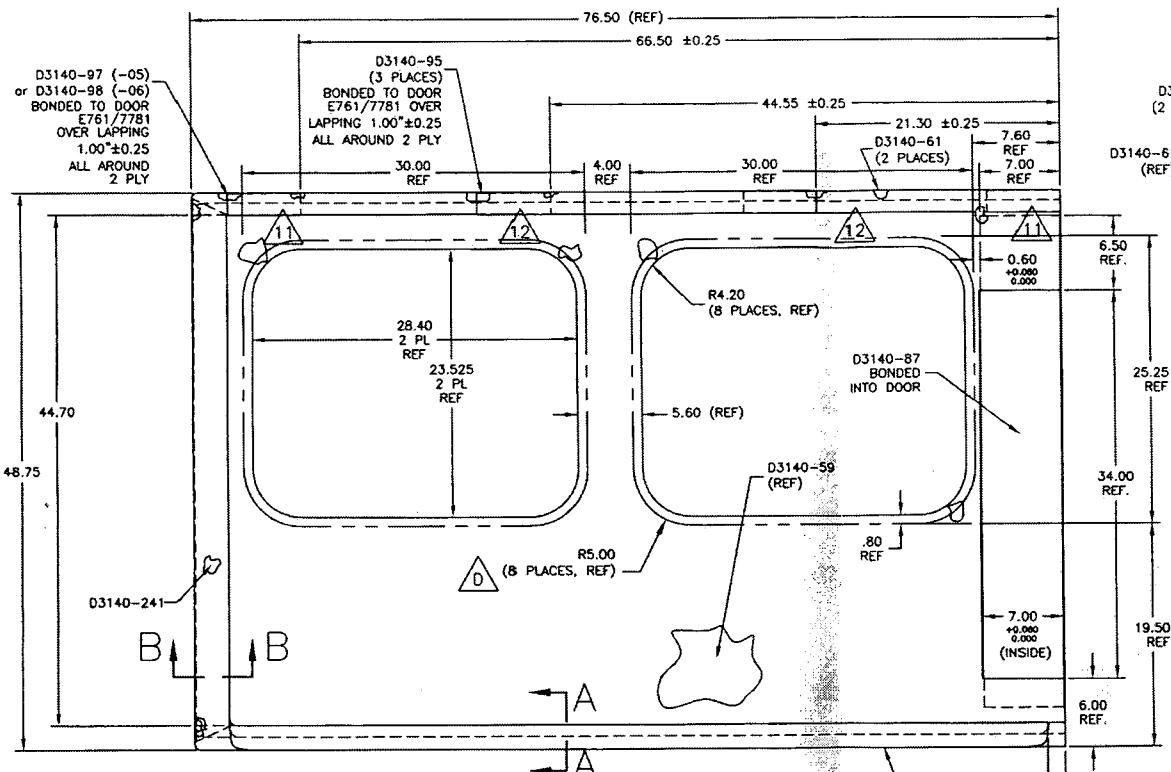


RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

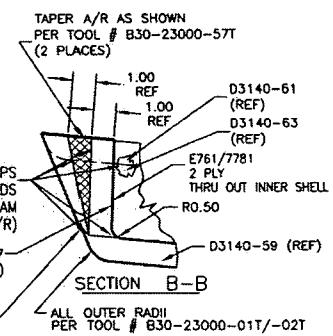
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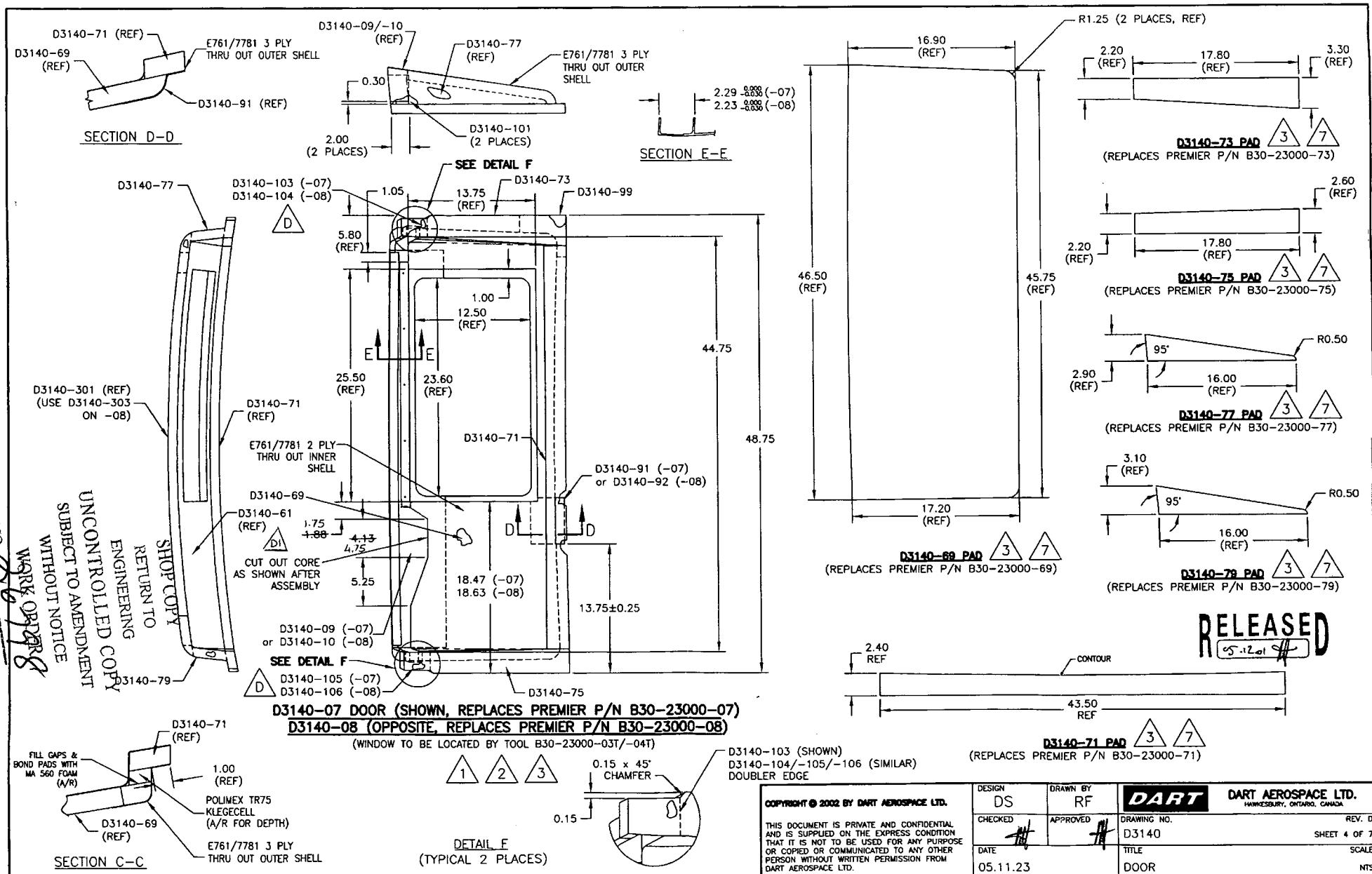
D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

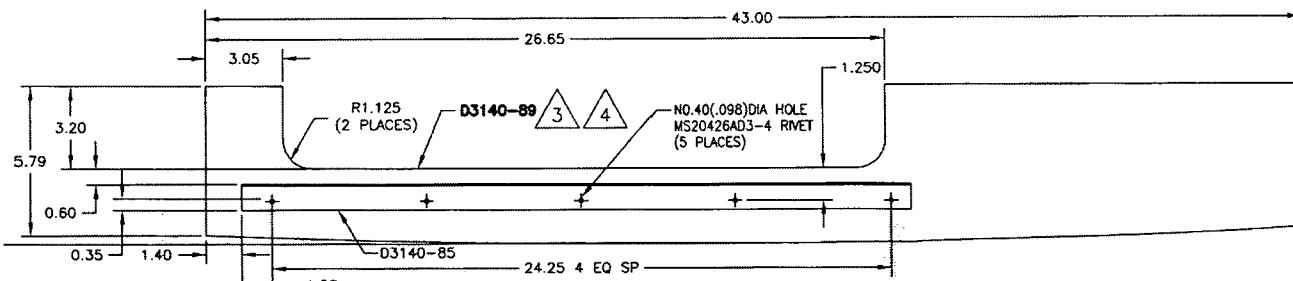
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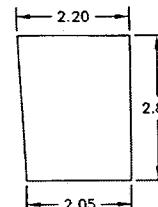
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CHECKED	APPROVED		REV. 0 D3140 SHEET 3 OF 7
DATE 05.11.23	TITLE DOOR	SCALE NTS	

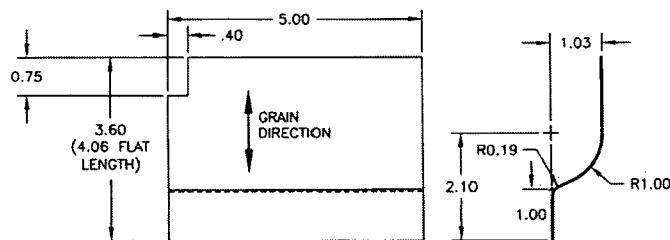




D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)
D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)

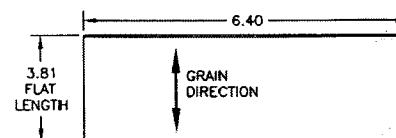


D3140-101 DOUBLER 4
 (REPLACES PREMIER P/N B30-23000-101)

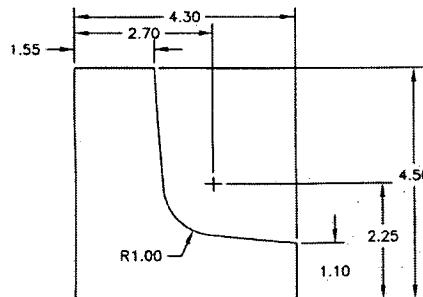


D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)

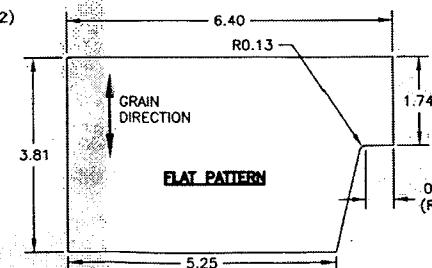
D3140-91 DOUBLER 4
 (SHOWN, REPLACES PREMIER P/N B30-23000-91)
D3140-92 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



D3140-95 DOUBLER 4
 (REPLACES PREMIER P/N B30-23000-95)



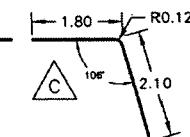
D3140-98 DOUBLER 4
 (REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
 (USE TO MAKE D3140-97/-98 DOUBLERS)

D3140-97 DOUBLER 4
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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 05/12/01



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SHEET 5 OF 7

DRAWING NO.

D3140

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DATE

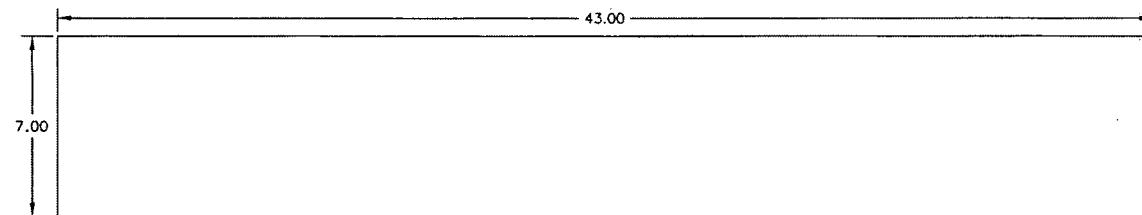
05.11.23

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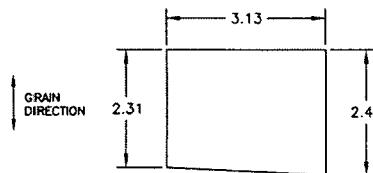
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DOOR

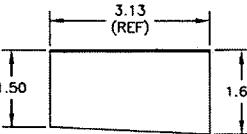
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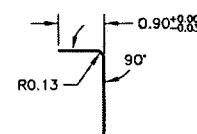
D3140-87 DOUBLER 4
(REPLACES PREMIER P/N B30-23000-87)



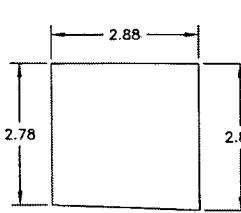
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



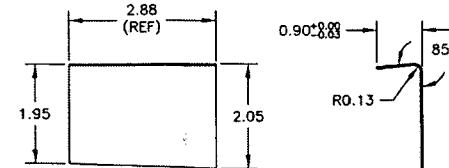
D3140-105 DOUBLER
D3140-106 OPPOSITE



4 D

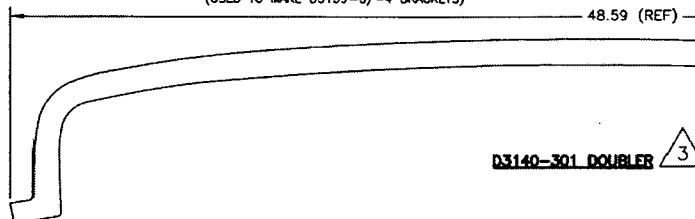


D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

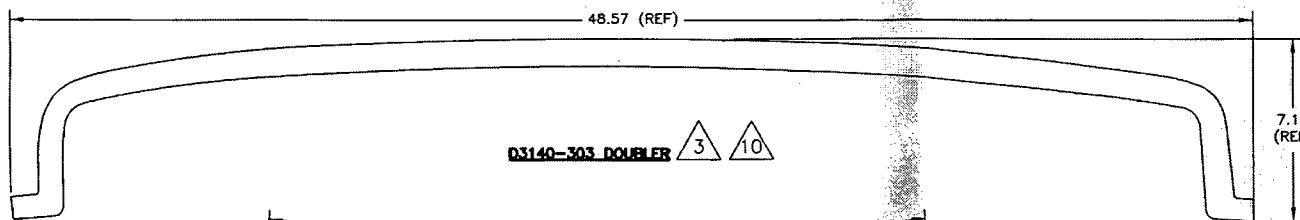


D3140-103 DOUBLER
D3140-104 OPPOSITE

4 D



D3140-301 DOUBLER 3 10



D3140-303 DOUBLER 3 10



D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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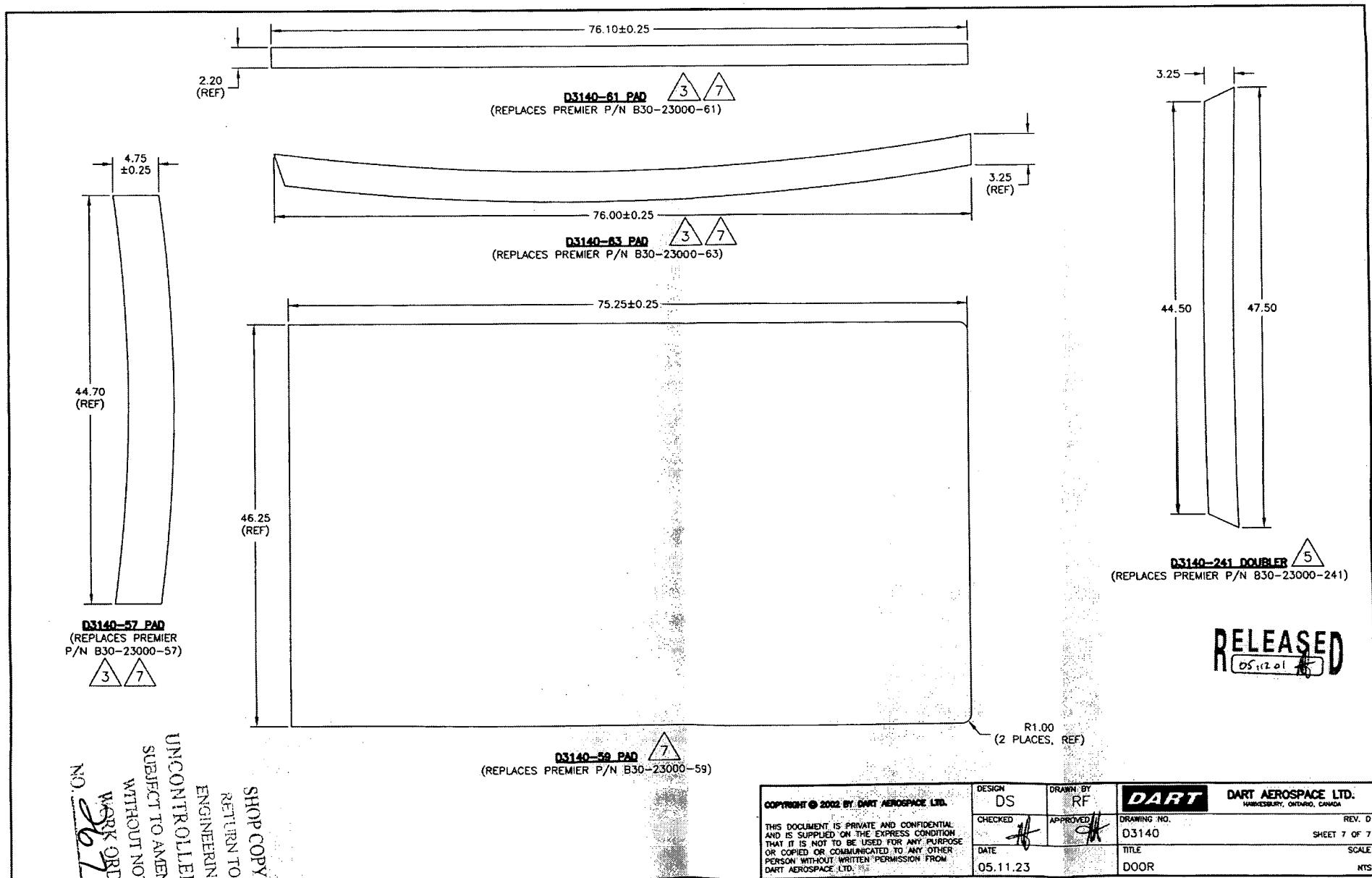
SHEET 6 OF 7

DATE
05.11.23

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D3140-59 PAD
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DATE 05.11.23				TITLE DOOR	SCALE NTS

WIDESPACE LTD

Work Order: B26798

2000-01-00

Part Number: 03140-303

1000 J. POLYMER SCIENCE: PART A

Rev

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

✓

First Article

1

Prototypes

1128

3/101
060425

Audited by:

Date: 06/04/25

Prototypes Are...What?

State:

12

Wide Change Left Isolate

Revised by	Approved
KL/CS	